

REO/PCT REC'D 17 SEP 2004
17 SEP 2003



PCT

WORLD INTELLECTUAL PROPERTY ORGANIZATION
International Bureau

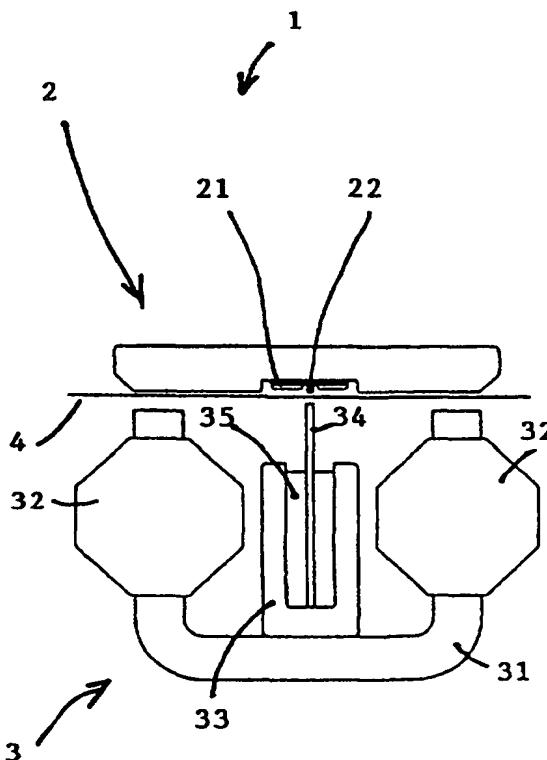
INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 7 : B31F 1/00	A1	(11) International Publication Number: WO 00/54966 (43) International Publication Date: 21 September 2000 (21.09.00)
(21) International Application Number: PCT/FI00/00205 (22) International Filing Date: 15 March 2000 (15.03.00) (30) Priority Data: 990561 15 March 1999 (15.03.99) FI		(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).
 (71) Applicant (for all designated States except US): MAPING KY, L. HUOTARI [FI/FI]; Atomitie 5 F, FIN-00370 Helsinki (FI). (72) Inventors; and (75) Inventors/Applicants (for US only): HUOTARI, Lauri [FI/FI]; Tammisaari 2 B 13, FIN-02940 Espoo (FI). HUOTARI, Lisakki [FI/FI]; Runeberginkatu 55 b A 29, FIN-00260 Helsinki (FI). HUOTARI, Jaakko [FI/FI]; Porvarinkuja 1 K 38, FIN-00750 Helsinki (FI). SIIKAMÄKI, Markku [FI/FI]; Mirjankuja 2 E 26, FIN-02230 Espoo (FI). GUT, Henryk [PL/PL]; Czerska 15/59, PL-00-732 Warszawa (PL). (74) Agent: LAITINEN, Pauli, S.; Patentti-Laitinen OY, P.O. Box 29, FIN-02771 Espoo (FI).		 Published With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments. In English translation (filed in Finnish).

(54) Title: METHOD AND DEVICE FOR WORKING PAPER, BOARD, OR SIMILAR

(57) Abstract

The invention relates to a method and device for working paper, board, or similar, in which method scoring, punching, perforation, or a similar operation is performed on the aforesaid material. The force for carrying out the work is created by means of an electromagnet (3). Scoring, for example, can be carried out by putting the paper (4) or similar between a scoring blade (34) and its counter-piece (21) and causing a rapid approaching movement between them, to carry out the scoring.



FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

Method and Device for Working Paper, Board, or Similar

The present invention relates to a method and device for working paper, board, or similar. More specifically, the scope of the aforesaid working may encompass scoring, perforation, punching, creating an opening, trimming, and other operations, which are performed on paper, board, and similar products, such as plastic films and sheets, and adhesive labels on backing sheets. In certain cases, the paper or paper-like products may be worked in bundles, with two or more sheets on top of each other.

10

Scoring, for example, takes place at present mainly in relatively large devices of the printing press type, in which there is a rotating roller, with suitable blades for carrying out the desired operation attached to its surface. Thus, scoring, for example, takes place by the blade attached to the aforesaid roller press the paper, board, or similar against a counter-surface, and simultaneously scoring it. If it is intended to carry out perforation, the blade has a suitable edge, part of which is intended to penetrate the paper or similar. Similarly, a blade can be used to cut an adhesive label attached to a suitable backing into appropriate parts, without nevertheless touching the backing. Of course, scoring can also be carried out using a manual device or a device in which motion is created by an electric motor.

15

A drawback in the cases described above is the large size and cost of the devices required. An additional drawback is that a large and clumsy and relatively heavy device cannot be sensibly attached to form a part of another device, such as a printing press or copier. Instead the device is, and must remain separate.

20

Naturally, there is a great difference in the amount of work needed when using two separate devices and when using a single device, in which another apparatus carries out another stage of the work. A manually operated device driven by muscle power is, in turn, slow and cumbersome to operate, while a device driven by a electric motor is slow, as it requires the rotation of the motor to be started, the work to be carried out, and the motor to be stopped.

25

The present invention is intended to create a method and device, by means of which the drawbacks referred to above can be eliminated and by means of which

any of the work stages referred to above or not referred to above can be carried out flexibly, with a minimum of labour, and efficiently.

5 The above and other advantages and benefits of this invention are achieved in the manner described in the characterizing sections of the accompanying Claims.

In the following, the invention is described in greater detail, with reference to the accompanying drawings, which show some general principles of some embodiments of the invention, without the invention being limited to them in any 10 way. It is self-evident, that many of the technical solutions in the embodiments presented can be replaced with other technical solutions, without, however, deviating from the basic principles and spirit of the invention.

15 Certain physical solutions are described in the drawings, while, for the sake of clarity, leaving out many parts of the device that are known from other contexts. The method according to the invention is explained by describing the devices shown in the drawings.

Thus:

20

Figure 1 shows a side view of a simplified diagram of one embodiment of the device according to the invention;

Figure 2 shows another alternative, also in side view;

25

Figure 3 shows a similar view of a third embodiment; and

Figure 4 shows yet another alternative way to construct a device according to the invention.

30

The basic principle of the invention is to use a high-speed, precise, and easily controlled electromagnetic force to carry out any operation, such as scoring, belonging to the area. An electromagnetic force is naturally known in many

connections but its application in this area is an insight that opens many possibilities.

Thus, Figure 1 shows one embodiment of the invention in a simplified diagram that
5 only shows the basic principle, and which lacks many accessories not necessary
to illustrate the principle according to the invention. The method according to the
invention will become apparent from the description of the device. Thus, the
device 1 includes a component 2, which is attached to a frame not shown in the
figure in any great detail, and which is made from a material (magnetizable
10 material), especially iron, that is moved by a magnetic force. This component may
be guided by guide rails, which are also not shown in the figures.

Specifically in this embodiment, the electromagnetic component, which is generally
marked with the reference number 3, is regarded as a fixed piece and component
15 2 as a moving piece, though in fact the reverse may be true, or both components 2
and 3 may move. The figure also shows component 2 as being the upper piece,
but component 2 may be just as well and perhaps preferably the lower piece, i.e.
the whole drawing would also be valid if turned through 180 degrees. The
components can also be turned to any other angle at all.

20 If desired, both components can also be magnetized with like poles or opposite
poles, creating an attracting or rejecting movement, thus allowing the
electromagnetic control of the movement in both directions and further
accelerating the operation. The magnitudes of the forces acting in different
25 directions can be adjusted to be equal or different.

Figure 1 shows an end view of the device. This means that the width of the whole
device is at least as great as that of the widest paper to be scored or otherwise
worked. For example, the width of the device, seen directly in the figure in a
30 direction away from the eye of the viewer, may be 30 cm or more. However, the
paper 4 may also travel in the manner shown, if the device is narrower than the
paper, but with scoring or another operation only being carried out in the area
delimited by the device.

- A component assembly 3, in which there is an electromagnetic construction comprising an iron core 31 and coils 32, 32, is also attached to the same or a separate frame. When an electrical current is connected to coils 32, an electromagnet is created, which strongly attracts component 2 to it. If the
5 attachment of component 2 to the body is made flexible or moveable, component 2 will move towards and onto electromagnet 3, unless the movement is otherwise limited to stop before contact has been made. However, a suitable flexibility or movement can be created in many different ways.
- 10 A holder 33, for scoring blade 32 or for devices for other purposes, is in the same totality as the electromagnet. Correspondingly, component 2 has a suitable groove 22, so that, when component 2 moves rapidly towards the electromagnet, the paper, board, or similar 4 remains between scoring blade 34 and counter-piece 21, thus creating a groove in it. If groove 22 is broader and deeper than shown in the
15 figures, a fold can be created in the paper or board.

It is obvious that the invention will function just as well in scoring, making holes, for example, for filing or binding, creating a perforation for tearing, making an opening, or cutting, or some other operation. Therefore the replacement of blade 34 is
20 arranged simply so that the blade is in a suitable, tight groove in the same frame as the electromagnet. Number 35 refers to a suitable material, in which the retaining groove has been made. Blade 34 can be changed by removing the old blade by pulling it to the side or lifting it out of the groove, then pushing the new blade in. Replaceable blades can be made in different thicknesses for scoring, or,
25 instead of scoring, the blade may be such that it can be used for perforation or making holes, or for shaping a metal wire that binds sheets of paper together, etc.

Figures 2 and 3 show a adapted embodiment of the device according to Figure 1. Thus, in both figures, the 'blade' 34 is attached to the body diagrammatically, at
30 the point marked by the line 36, for example, by means of threads or in some other suitable manner, particularly by using some rapidly openable/closable attachment system, many of which are known in different fields. The blade in Figure 2 can be flat at the end facing component 2, so that it can be used, for example, for laminating, especially if it can be heated. Another possible alternative for the blade

to have a suitable patterning, which is impressed in the paper, board, plastic, or similar. This might be raised patterning or Braille printing. Further, the blade can be adapted for some particular form of wire binding, to close a binding wire.

- 5 Figure 3 shows a perforation version. Thus, in component 2 there is a hole, or a material 23 acting flexibly as a cushion, into which a perforation bit 37 at the end of blade 34 enters, to make a hole in the paper or similar. Other applications, such as cutting or making an opening, can be easily constructed on the basis of the above.
- 10 Figure 4 shows one means of creating movement in component 2. In this case, component 2 is suspended, by bolts 24 or similar, in a cradle 25 attached, by bolts 26 or similar, to the frame of the device, which is not shown in the figures. The flexibility that allows component 2 to move towards and away from magnet 3, is achieved by either the flexible attachment of bolts 24 and/or 26, or by making
15 cradle 25 from a material that flexible enough to permit the movement. Many other kinds of suspension or attachment are obviously possible.

The method and device according to the invention are extremely fast, compared, for instance, to the much used embodiment driven by an electric motor. In the
20 embodiments shown in the figures, the force is transferred entirely to the movement required to carry out the operation and to carrying out the task. However, the invention can also be applied in such a way that the force is transmitted to its object through a suitable system of levers. In this case too, the lever system is extremely simple and the loss of power small.

25 As stated above, the device according to the invention is very fast. Thus, if a more powerful scoring or other operation is desired, a double impact, or multiple impacts can be made, so that the score made by them in the paper or board or similar will naturally be greater than that made by a single impact.

30 A multiple impact is useful when using an opening blade, when the device according to the invention can be used for making openings in thicker grades of board, or simultaneously in many layers of paper or board, by hacking a punch or other blade at a high or relatively high frequency through board, paper, or pile of

board, or paper. In this case, the blunting of the blade can be compensated for by the number of impacts, while increasing the number of impacts will allow the same device to penetrate more resistant material. It is also possible at the same time to adjust the distance between the magnetized surfaces, or the current to the 5 magnetic coils, to vary the impact force as required.

In the device according to the invention, the time between the operations being carried out can be exploited by using the current to charge batteries or capacitors, when power can be recharged for the next work stage during the rest period 10 before it. This will, for example, reduce external interference to telephone traffic, compared to the power required for electric motors. The advantages of the device, when used in operations that are repeated many times in sequence, increase in proportion to devices driven by electric motors, because in electric motor solutions it is extremely difficult to carry out the starting stage, work stage, and stopping 15 stage at a rapid tempo.

As stated above, the device can be as broad or broader than the piece being worked, but may also be narrower, depending on the circumstances. The force is directed uniformly over the entire width, unlike in devices, in which, for example, 20 an axle is rotated from its end, so that the forces transmitted over the length of the axle may vary at different points, due to distortion and similar causes.

It is clear, that the operating position of the device is a factor of secondary importance in the device and the application of the principle according to the 25 invention. The device is simple and is extremely reliable. In addition, a device according to the invention is small and compact. Thus, it is suitable for installation, for example, as part of a printing press or copier, so that scoring, perforation, or similar operations can be carried out on the paper being copied or printed, directly after the copying or printing line. This will save a great deal of time and obviously 30 simplify the handling of the paper, because it eliminates many of the transfers and adjustments of the paper previously necessary out as intermediate work stages.

Several devices according to the invention can also be set side by side, when the operating area may be very great. The movement created by the electromagnet

can also be transmitted, for example, outside the area of electromagnet 2 by, for instance, placing scoring blades at the ends of component 2. There are numerous functioning variations that come within the scope of protection of the invention.

- 5 If, in practice it is sensible to construct the device according to the invention as two or more parts, this can be done easily by, for example, locating the parts either sequentially or also beside each other. In practice, in other words, a certain length can be formed of two or more sequential parts, with the total length desired.
- 10 The invention can be adapted in many ways, while nevertheless remaining within the scope of the protection of the inventive idea and the accompanying Claims.

Claims

1. A method for working paper, board, or similar, in which method scoring, punching, perforation, opening, cutting, or a similar operation is carried out on the material referred to in the method, in which operation electromagnetic forces are used, **characterized** in that the aforesaid operation is carried out by creating, with the aid of an electric motor effect, at least one rapid, back and forwards movement in the tool and/or its counter-piece.
2. A method according to Claim 1, **characterized** in that the scoring or similar operation is carried out by applying the effect of the mutual movement between an electromagnet (3) and a counter-piece (2).
3. A method according to Claim 1, **characterized** in that the force created by an electromagnet and carrying out the above operation, is transmitted to the object of the work, by means of joints and/or lever arms.
4. A method according to Claim 1, **characterized** in that an electromagnet is used to create a linear motion.
5. A method according to Claim 1, **characterized** in that the work stage is carried out as an operation twice or more in rapid sequence.
6. A method according to Claim 1, **characterized** in that in the time between the work stages, energy is charged into batteries or capacitors for use in the next stages.
7. A device for working, such as scoring, punching, perforating, creating openings, cutting, or similar, paper, board or similar, including of a component (3) operating on an electromagnetic principle, **characterized** in that it includes a means (34) for performing the desired operation, a counter-piece (2, 21, 22) to the means (34), and a device for conducting electricity to the component (3) to bring it and the counter-piece (2) towards each other with a rapid, striking movement, to perform the aforesaid operation.

8. A device according to Claim 6, **characterized** in that the electromagnet (3) is permanently attached to a frame and counter-piece (2) moves towards and away from the magnet, if desired running on guides.

5 9. A device according to Claim 7 or 8, **characterized** in that it includes a blade (34), which can be changed to suit different purposes.

10 10. A device according to one of the previous Claims 7 – 9, **characterized** in that it includes a means, such as a battery and/or capacitor, for storing energy, to be used in the next work stage.

11. A device according to one of the previous Claims 7 – 10, **characterized** in that the device is assembled from two or more components, set either in sequence or parallel to each other, containing an electromagnet (3).

1/2

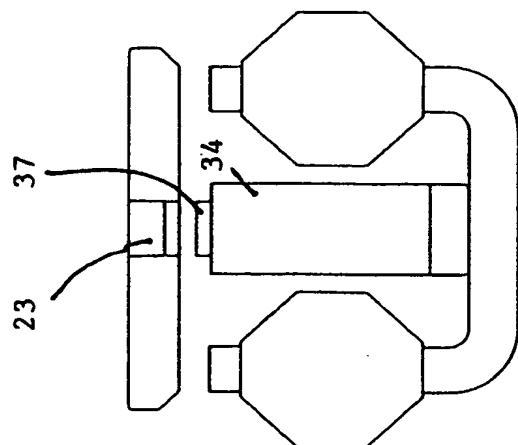


FIG. 3

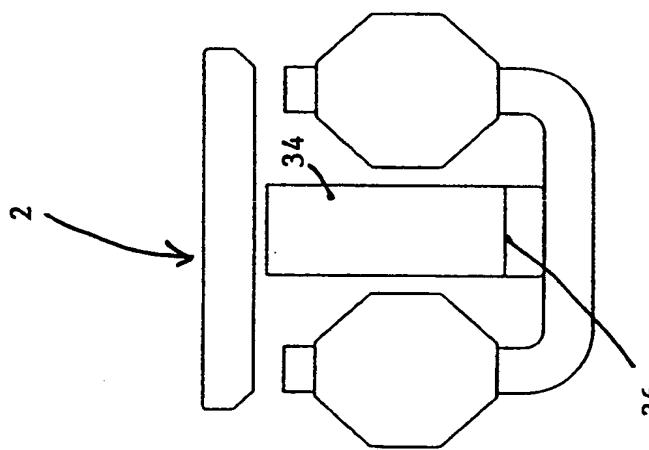


FIG. 2

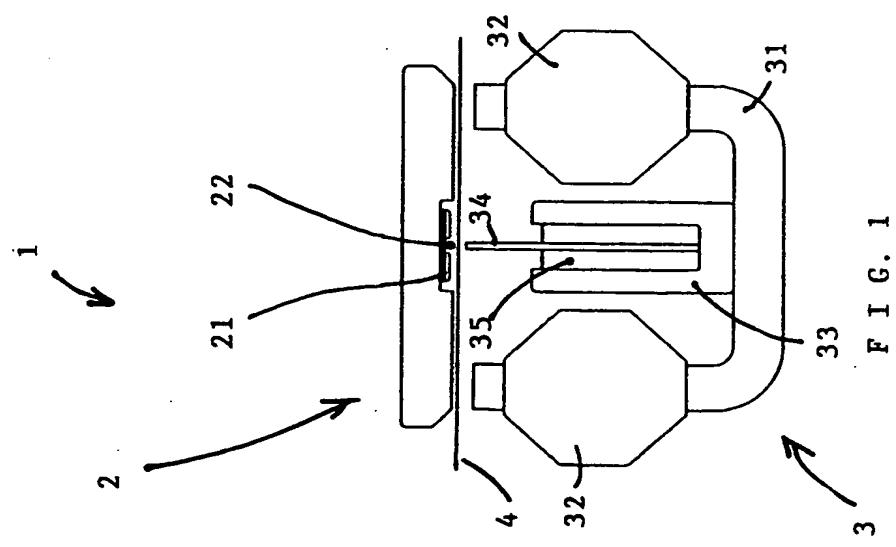


FIG. 1

2/2

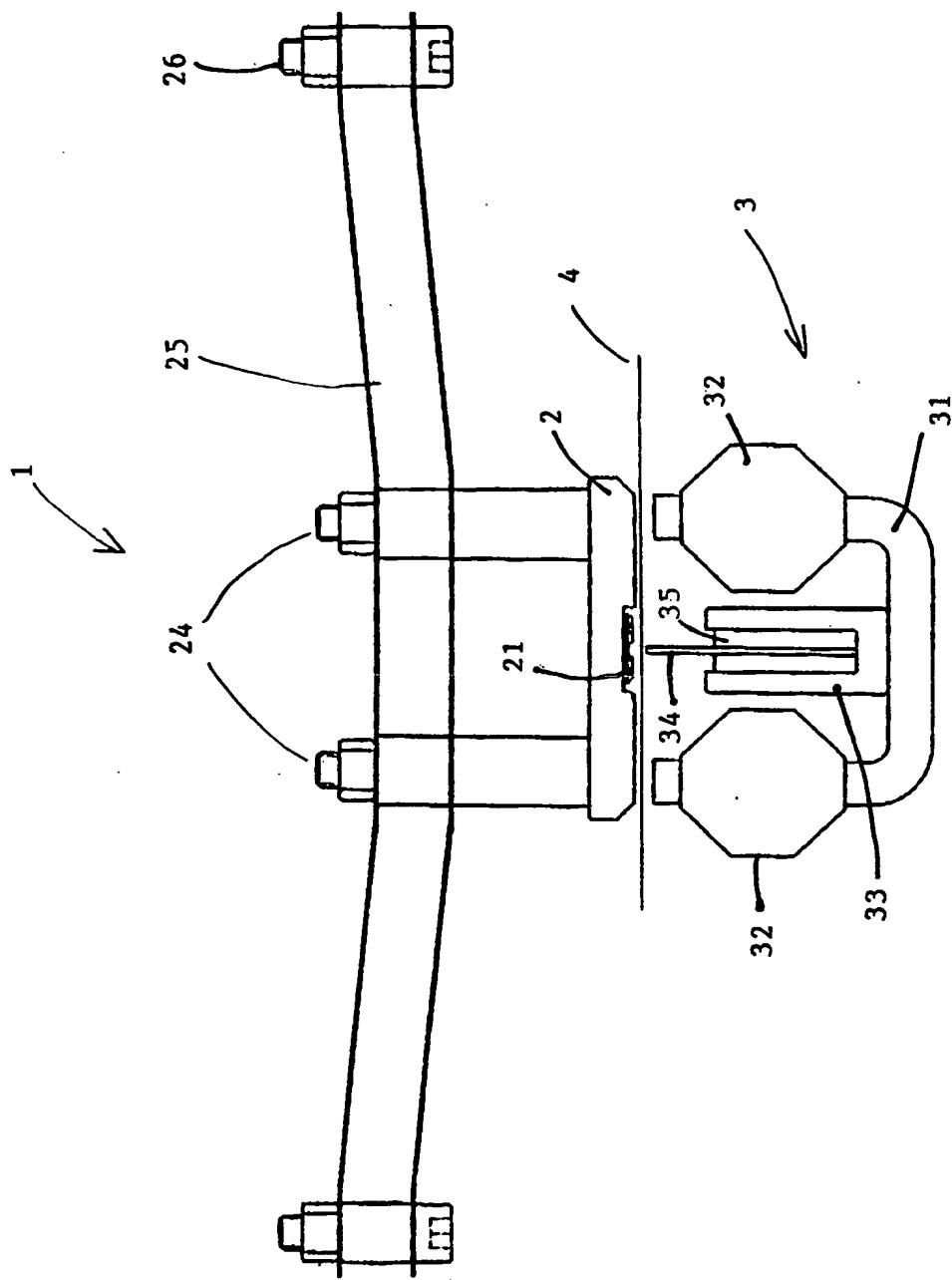


FIG. 4

INTERNATIONAL SEARCH REPORT

International application No.

PCT/FI 00/00205

A. CLASSIFICATION OF SUBJECT MATTER

IPC7: B31F 1/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC7: B31F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5617785 A (WEN C. LO), 8 April 1997 (08.04.97), column 2, line 35 - column 3, line 31 --	1-11
X	EP 0890429 A1 (AGNATI S.P.A.), 13 January 1999 (13.01.99), column 6, line 37 - column 7, line 22 -- -----	1

Further documents are listed in the continuation of Box C.

See patent family annex.

* Special categories of cited documents	"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
"A" document defining the general state of the art which is not considered to be of particular relevance	"X" document of particular relevance: the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
"E" earlier document but published on or after the international filing date	"Y" document of particular relevance: the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
"L" document which may throw doubt on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"&" document member of the same patent family
"O" document referring to an oral disclosure, use, exhibition or other means	
"P" document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

19 June 2000

Date of mailing of the international search report

10 -07- 2000

Name and mailing address of the ISA/
Swedish Patent Office
Box 5055, S-102 42 STOCKHOLM
Facsimile No. + 46 8 666 02 86

Authorized officer

Anette Hall/Els
Telephone No. + 46 8 782 25 00

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No.

PCT/FI 00/00205

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 5617785 A	08/04/97	NONE	
EP 0890429 A1	13/01/99	IT SV970036 A	11/01/99